

Work Order ID 158343

Monday, March 20, 2017 1:50:49 PM

158343

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Item ID: D5393-043 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Strut Weldment
Start Date: 3/20/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 3/31/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference: SCHEDULED/S

Approvals: Process Plan: umf Date: 17-3-20 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5393	B								

110 Weld per dwg A/R S.S. rod Batch: 113442 0.00***110***

Large Fab

Large Fab

Memo

0.83

1- CUT TUBE TO LENGHT AS PER DWG

2- WELD STUD TO STRUT AS PER DWG

3- GRIND WELD FLUSH

MAR 20 2017

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00

120

QC

Quality Control

Memo

0.00

1 EL / 17-3-20① 17-03-21 DAS
9
9-89

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC5- Inspect part completeness to step on W/O	0.00							
130									
QC	Memo	0.02							DAS 9 9-89
Quality Control									
160	Identify as per dwg & Stock Location: <i>SA GA</i>	0.00							
160									
Packaging	Memo	0.01							<i>1x Sp17-03-21</i>
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.10							<i>17/3/23</i>
Quality Control									

DAS
21
9-89

MAR 21 2017

Picklist Print

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Work Order ID: 158343

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Parent Item: D5393-043

D5393-043

Parent Item Name: Strut Weldment

Start Date: 3/20/2017

Required Date: 3/31/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 16.02.01 NEW ISSUE DD VERF:JLM IPP
REV:B 17.01.27 AS PER DWG REV.B2 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D5393-3

Manufactured

No

110

Each

2.0000

2

2

D5393-3

Stud

**

Q 17-3-20

Location

Loc Qty

Loc Code

ST167

2

156149

2

2

M304TR0.500W.049

Purchased

No

110

f

41.7466

1.7

1.7

M304TR0 500W 049

304 RD Tube .500 x .049W

**

FF MAR 20 2017

Location

Loc Qty

Loc Code

GA002

41.746573

M127937

1.1741

M132872

4.589736

M136569

6.282737

M136846

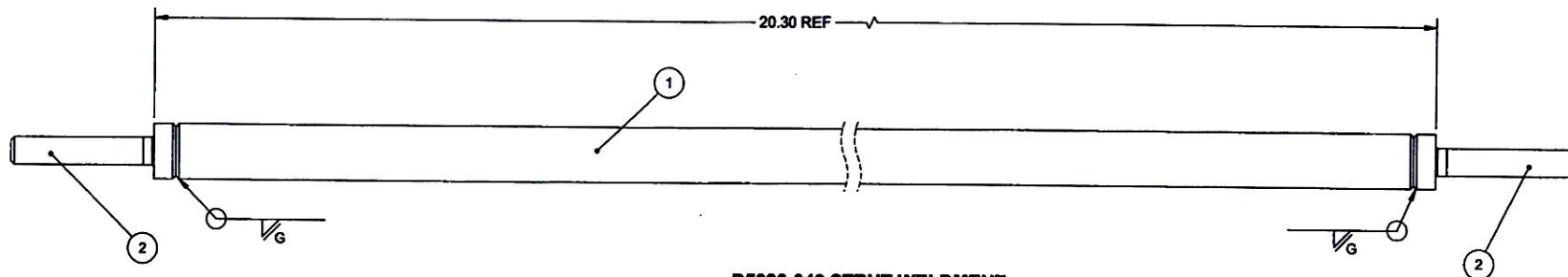
9.7

M137091

20

1.7

ITEM	QTY	P/N	DESCRIPTION
	X	D5393-043	STRUT WELDMENT
1	1	D5393-1	STRUT
2	2	D5393-3	STUD



D5393-043 STRUT WELDMENT

mf
#158343

NOTES:

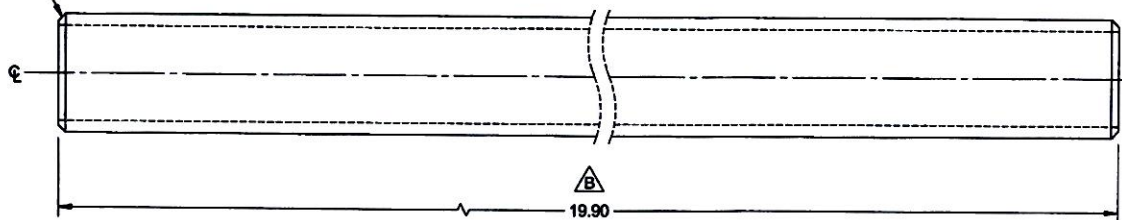
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.51 lbs
- 8) WELD PER DART QSI 004

RELEASED
2017-02-10

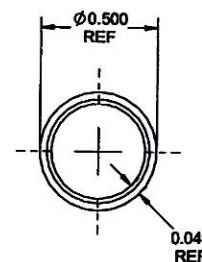
APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	NO		
CHECKED	AJS	DRAWING NO.	REV. B
MFG. APPR.	DD	D5393	SHEET 2 OF 4
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	STRUT ASSEMBLY	NTS
DATE	16.12.19	COPYRIGHT © 2016 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

0.030 x 45°
CHAMFER, 2 PL



D5393-1 STRUT



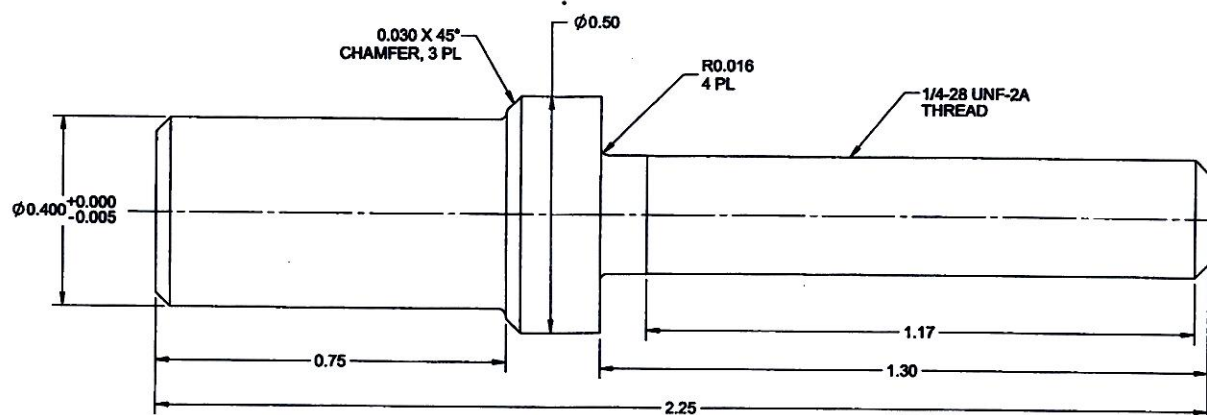
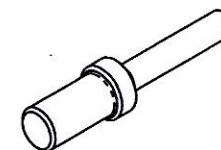
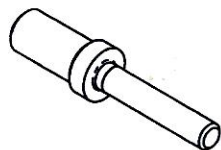
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING
PER ASTM A213 OR ASME SA213 OR ASTM S269
REF. DART SPEC M304TR0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.40 lbs

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MFG. APPR.	DD	D5393	SHEET 3 OF 4
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DE APPR.	DS	STRUT ASSEMBLY	NTS
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D5393-3 STUD

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND BAR
PER ASTM A276
REF. DART SPEC M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.06 lbs

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2017-02-10

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